

Date: Friday, 01/09/2006 1:00:57 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 28188	
Estimate Number : 10574	
P.O. Number : N/A	Part Number : D34531
This Issue : 01/09/2006 S.O. No. : N/A	Drawing Number : D3453 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 15/08/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27798	Material : N/A
Written By : <u> </u>	Due Date : 31/08/2006 Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : A 05.09.27 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	Inventory
-----	-----------	-----------



Comment: Qty.: 0.2880 f(s)/Unit Total : 2.8800 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: M101549 14"

MS 06/09/01

2.0	LATHE CONV.	CONVENTIONAL LATHE
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**Comment:** CONVENTIONAL LATHE

→ Done on Hardinge CNC

3.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL1-Turn as per Folio FA577 Rev: AA & Dwg D3453 Rev: A

2- Deburr as per dwg D3453

MS 06/09/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/09/02

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #11-Mill as per Folio FA577 Rev: AA & Dwg D3453 Rev: A

2- Deburr as per dwg 3453

J.F. 06/09/06

(9)

Date: Friday, 01/09/2006 1:00:58 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28188

Part Number: D34531

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/09/06

⑨

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

06/09/06

9

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/06

9

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06-09-06

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

PD 06-09-07

⑨

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07

⑨

Job Completion




U 06-09-07

Sept 1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 28188		
Estimate Number	: 10574		
P.O. Number	:	Part Number	: D34531
This Issue	: 15/08/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3453 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 27798	Drawing Revision	: A
	Type : MACHINED PARTS	Material	:
Written By	: 	Due Date	: 31/08/2006
Checked & Approved By	:	Qty:	10
Comment	: A 05.09.27 New issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304R1250	Inventory
-----	-----------	-----------



Comment: Qty.: 0.2880 f(s)/Unit Total : 2.8800 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: _____

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA577 Rev: _____ & Dwg D3453 Rev: _____
 2- Deburr as per dwg D3453

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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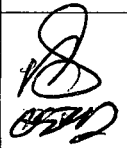
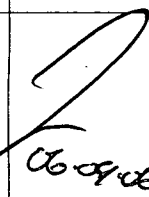


Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA577 Rev: _____ & Dwg D3453 Rev: _____
 2- Deburr as per dwg 3453

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/06	5	The index fixture moved. Set-up error		Scrap: no replace. destroy.	J.F. 06/09/06			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28188

Part Number: D34531

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

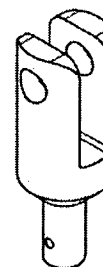
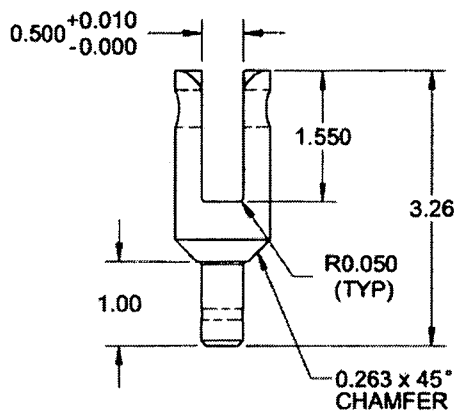
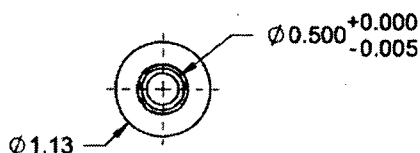
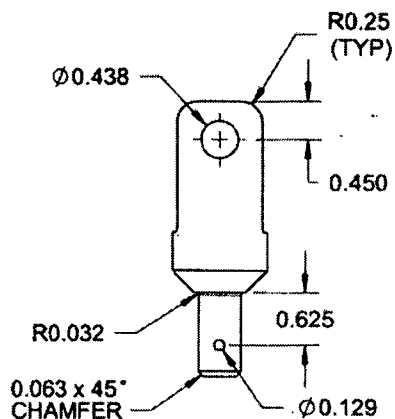
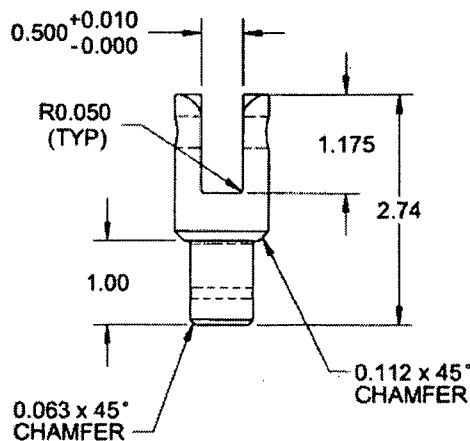
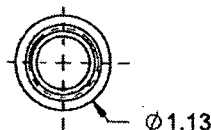
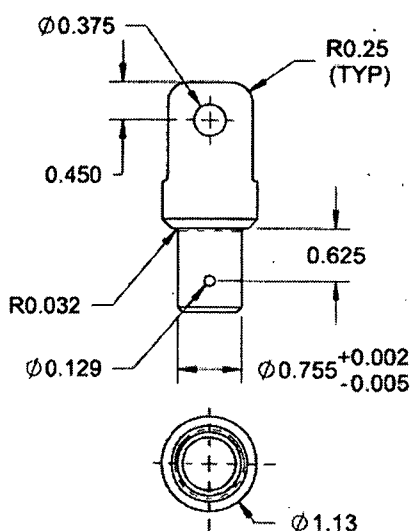

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

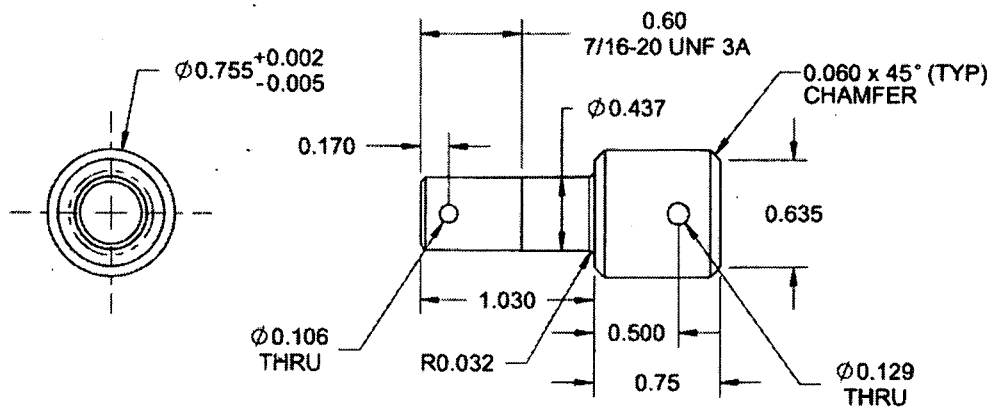
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 [Signature]

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries